



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4710-1
Job Sheet 169895



Part No: D4710-1

Job Qty: 6 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/3/18

Job Tracking No:

Due Date: 1/15/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12-09-11 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/13/18	0.00	0.00	Start Up Machining-3		<i>MJP 18/02/14</i>
100	CNC Lathe	6 pcs		1/15/18	0.00	0.89	Doosan		<i>MJP 18/02/14</i>
110	QC	6 pcs		1/15/18	0.00	0.00	QC2 Machining-3		<i>MJP 18/02/14</i>
120	QC	6 pcs		1/15/18	0.00	0.00	QC8 Machining-3		<i>MJP 18/02/14</i>
130	Packaging	6 pcs		1/15/18	0.00	0.00	Packaging3-2		<i>MJP 18/02/14</i>
140	QC21-SA	6 Ea		1/15/18	0.00	0.00	QC21		<i>MJP 18/02/14</i>

Part Op 100 - TURN AS PER DWG FOLIO REV: _____ DWG REV: _____ DEBURR

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

DAS
21
9-89

FEB 14 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MDELRLNR1.500	0	9	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.690Inches ± 0.010	0.690 0.700 0.680	Radius	
2	Spacer	0.395Inches ± 0.010	0.395 0.405 0.385	Radius	
3	Spacer	0.820Inches ± 0.010	0.820 0.830 0.810	Countersink, Diameter	
4	Spacer	90.000Degrees ± 0.500	90 90.500 89.500	Angle	
5	Spacer	0.600Inches ± 0.030	0.580 0.630 0.570		
6	Spacer	90.000Degrees ± 0.500	90 90.500 89.500	Angle	
7	Spacer	0.125Inches ± 0.010	0.127 0.135 0.115		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																			
Large Fab ☐	Composite ☐	Supplier ☐																				
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																		
Description Work Order Deviation			Disposition																			
			Completed By																			
			Lead hand / Supervisor Approval Verification																			
			QC / QA Coordinator Approval																			

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 www.dartaerospace.com



Container No: S042139



Part: D4710-1

Serial No/Batch: S042139

Revision: D4710

Inspector:

Date: 02/14/18 08:38 AM

FAULT CATEGORY

effect lete/Unqualified	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
	☐ Weld	☐ Part Incorrect
	☐ Wrong Stock Pulled	☐ Part Lost/Missing
plete/Unclear	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Misabeled	☐ Finish
	☐ Fit/Function	☐ Misread
	☐ Misaligned/off center	☐ Turning Sequence

